

ACTEGA Kelstar

Aqueous Coating Troubleshooting Guide

TROUBLESHOOTING GUIDE FOR IN LINE AQUEOUS COATINGS

PROBLEM	CAUSE	CORRECTIVE ACTION
Coating bead on tail edge of sheet.	Applicator roller speed running faster than blanket roller.	Reduce roller speed.
	Too much pressure between blanket and back cylinder.	Release back cylinder pressure slightly.
Voids in coating. Uneven coating film on sheet.	Uneven nip pressure between applicator roller and blanket.	Adjust rollers to blanket KISS impressions.
	Not enough squeeze between blanket and back cylinder.	Increase back cylinder pressure until even coating film is achieved.
	Dried coating on blanket or rollers.	Clean blanket or rollers.
Coating foaming.	Pumping coating too hard forcing air into coating.	Slow coating pump down
	Coating does not contain enough defoamer to accommodate high sheer anilox coater and circulation system.	Add manufacturers recommended defoamer press side to reduce foaming.
Bad lay of coating over ink (mottling).	Wax in ink other than polyethylene.	Use wax free inks. Limit wax inks to polyethylene.
	Dirty coating blanket. Too much back cylinder pressure.	Clean blanket. Release back cylinder pressure slightly.
Orange peel effect.	Too much coating transfer to blanket. Coating viscosity too high.	Apply more pressure between nips. Slow roller speeds to apply less coating to blanket. Lower viscosity of coating.

Contact ACTEGA Kelstar at 856 829 6300 or info.actega.kelstar@altana.com for additional information or technical assistance.

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Back trap of ink on blanket	Too little coating being transferred from rollers to blanket.	Increase roller speed to transfer more coating to blanket.
	Too much back cylinder pressure (impression cylinder).	Unpack blanket packing or reduce pressure from back cylinder to blanket.
Ridges in coating applicator roller	Roller is set improperly.	Reset roller pressure, check coating roller.
Coating build up on sides of sheets	Too much pressure between applicator roller or blanket and back cylinder.	Release pressure between rollers (open nips).
Offset of ink in pile	Coating viscosity too low.	Change coating to higher viscosity.
	Not putting enough coating on sheet.	Speed up coating unit or open nip between rollers.
	Insufficient drying.	Dry with adequate air knife and IR.
Mud cracking	Coating drying too fast.	Slow down coating dry speed.
	Coating over excessive ink density.	Select coating with better film formation properties.
Picking and sticking of sheets in pile	Too much coating being applied to sheet.	Slow down unit speed. Reset NIP applicator and roller pressures.
	Coating viscosity too high.	Lower viscosity of coating.
	Coating drying too slow.	Select a faster drying, better block resistant coating.
		Press drying system is not properly functioning.
	Insufficient drying.	Increase air movement via air knife.
		Run spray powder.

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Spitting and slinging	Coating build up on edge of roller.	Reduce viscosity. Adjust roller settings speed.
Sheet curl	Stock is absorbing too much water.	Stock moisture content is too low, less than 5%, leading to excessive curl as water is absorbed from aqueous coating.
	Too much heat.	Reduce coating weight or viscosity.
		Use faster setting inks with lower water pick up.
Volcanoing	Volatiles in ink are being forced through the ink causing a small volcano looking void.	Lower dryer settings to lower temperature in pile.
		Use higher solids ink with less volatiles.
		Dry inks more before applying and drying coating.

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